

Work Order ID 162448

Tuesday, June 06, 2017 4:57:33 PM

162448

Page 1

Item ID: D206-836-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

20170607

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
GA202-2	A

100

Document Control

JUN 19 2017**DAS
6
9-89*****100***

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D206-836-111 CHG001

**2 DAS
27
9-89****JUN 19 2017**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

**2 JUN 19 2017 DAS
6
9-89 DAS
28
9-89**

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

**2 DAS
27
9-89
JUN 20 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162448

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162448

Page 2

Item ID: D206-836-111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Antenna Mount Universal
Start Date: 5/31/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/5/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2	DAS 27 9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-836-111 Location : FG122								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

JUN 20 2017

17/6/21

JUN 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 162448

162448

Parent Item: D206-836-111

D206-836-111

Parent Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.04.18 NEW ISSUE DD VERF:JLM
13.07.18 AS PER ECN13-561 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1 *D4853-1* Top Bracket		Manufactured	No			110	Each	2.0000	1	2	DAS 6 9-89		DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST519				2					
				148141				2					
D4853-3 *D4853-3* Top Bracket		Manufactured	No			110	Each	12.0000	1	2	DAS 6 9-89		DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST519				12					
				109076				12					
D4853-5 *D4853-5* Top Bracket		Manufactured	No			110	Each	18.0000	1	2	DAS 6 9-89		DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST519				18					
				109077				18					
D4853-7 *D4853-7* Top Bracket		Manufactured	No			110	Each	13.0000	1	2	DAS 6 9-89		DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST519				13					
				147092				12					
				148780				1					

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Shop Packet Print

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Picklist Print

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Work Order ID: 162448

162448

Parent Item: D206-836-111

D206-836-111

Parent Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D4854-1 Manufactured No

110 Each

3.0000

1 2

D4854-1

Lower Bracket
DAS 27 9-89

**

DAS

JUN 19 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

st526

3

159107

3

D4854-3 Manufactured No

110 Each

13.0000

1 2

D4854-3

Lower Bracket

**

DAS

JUN 19 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

st526

13

109081

12

148778

1

D4854-5 Manufactured No

110 Each

4.0000

1 2

D4854-5

Lower Bracket

**

DAS

JUN 19 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

st526

4

158151

4

D4854-7 Manufactured No

110 Each

10.0000

1 2

D4854-7

Lower Bracket

**

DAS

JUN 19 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

st526

10

147723

6

148781

4

Picklist Print

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Work Order ID: 162448

162448

Parent Item: D206-836-111

D206-836-111

Parent Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

D4855-1 Manufactured No

110 Each 13.0000 1 2

D4855-1

Antenna Bracket

**

DAS

6

9-89

JUN 19 2017

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st526

13

158506

3

158888

10

D2732-030

Manufactured No

110 Each 342.0000 2 4

D2732-030

Rubber Cushion 3"

**

DAS

6

9-89

JUN 19 2017

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

1

150011

1

ST410

341

158347

100

161656

41

162073

200

AN4-16A

Purchased No

110 Each 458.0000 2 4

AN4-16A

Bolt

**

DAS

6

9-89

JUN 19 2017

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

300

M136986

100

M137507

200

ST343

153

M137412

153

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Shop Packet Print

Page 169

Picklist Print

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Page 170

Work Order ID: 162448

162448

Parent Item: D206-836-111

D206-836-111

Parent Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

AN4-11A Purchased No

110 Each 159.0000 2 4

AN4-11A
BOLT

**

DAS

6
9-89

JUN 10 2017

DAS

28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG 20

120731 20

ST344 139

M137495 139

NAS1149D0432J Purchased No

110 Each 1,180.000 8 16

NAS1149D0432J
WASHER

**

DAS

6
9-89

JUN 19 2017

DAS

28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA 24

m131026 24

ST260a 1000

m137459 1000

ST264 156

m134676 156

Picklist Print

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Work Order ID: 162448

162448

Parent Item: D206-836-111

D206-836-111

Parent Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017

Required Date: 6/5/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

3,041.000

4

8

MS21042L4

Nut

**

DAS
6
9-89

DAS
27
9-89

JUN 19 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

51

m135058

51

OVER007

2400

m137402

400

m137544

1000

m137680

1000

ST303

580

m137371

580

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT

Work Order ID 162448

Tuesday, June 06, 2017 4:57:33 PM

Item ID: D206-836-111

Revision ID:

Item Name: Crosstube Antenna Mount Universal

Start Date: 5/31/2017 Start Qty: 2.00

Required Date: 6/5/2017 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Cust Item ID:

Customer:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
GA202-2	A

100

Document Control

JUN 19 2017

0.00

DAS
39
9-89

JUN 29 2017

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels as per PPP D206-836-111 CHG001

0.00

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.06